

(D)

PLOT SCALE: 1/2=1

DWG. SCALE:1

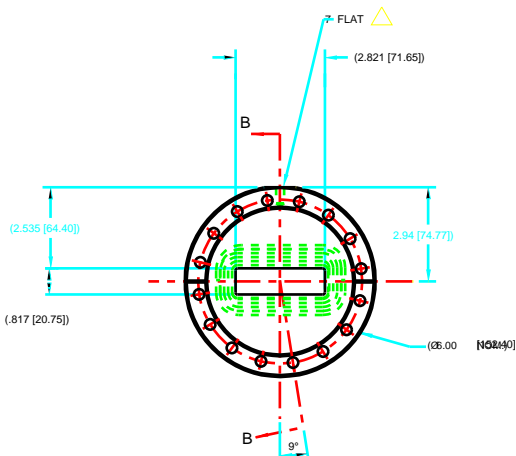
### ASSEMBLY PROCEDURE:

1. WELD CHAMBER (ITEM #1) TO 8.0" FLANGE (ITEM #2)-ONE END ONLY.

2. SLIDE SHIELDED CAN IN PLACE -

[ WELD CHANNEL R.H. (ITEM 3) TO CHANNEL L.H. (ITEM 4) AND END PLATE (ITEM 5)  
INSERT LEAD COIL (ITEM 6) ].

3. WELD CHAMBER (ITEM #1) TO 8.0" FLANGE (ITEM #2)-SECOND END.



NOTES:

1. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.

ALCATEL SAM-110TCL  
Du PONT CEC 24-120B  
VARIAN MS-9, MS-90 OR MS-18

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TRESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE CHAMBER (BAGGING) WITH HELIUM. THE CHAMBER WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.

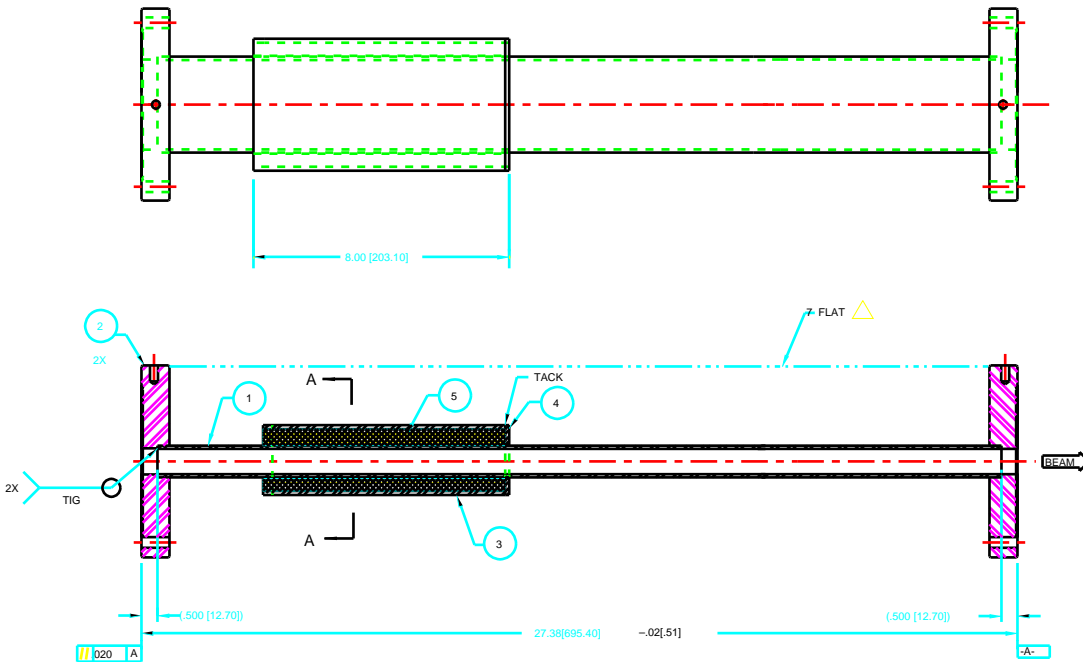
4. DIMENSIONS IN [ ] ARE MILLIMETERS

5. SHIELDED CAN SHALL BE TO SLIDE FREELY

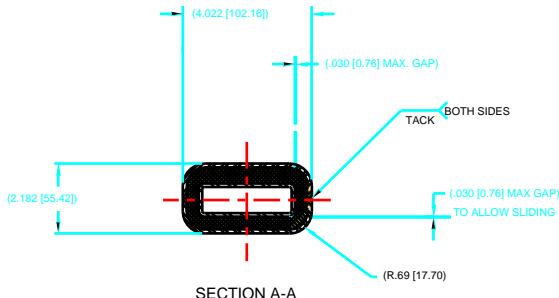
6. THIS UHV PART MUST BE BAKEABLE TO 170 C.

7. BEFORE WELDING POSITION VAC CHAMBER ASSY  
ON A FLAT SURFACE TO MAKE THE TWO FLATS ON THE  
FLANGES COPLANAR.

8. MAX. TWIST ALLOW IN THE CHAMBER 2.5MM TOTAL



SECTION B-B



SECTION A-A

A2287301	5	P4105090602-310701-0	J2 TRANSITION PIPE 3-ID-A, LEAD COIL	LEAD GRADE "C"	1
A2267500	4	P4105090602-310106-0	J2 TRANSITION PIPE 1-ID-B, END PLATE	304SS	1
A2336800	3	P4105090602-310704-0	J2 TRANSITION PIPE 3-ID-A, CHANNEL	304SS	1
A2336900	2	P4105090602-310705-0	J2 TRANSITION PIPE 3-ID-A, END FLANGE	304SS	2
A2328500	1	P4105090602-310703-0	J2 TRANSITION PIPE 3-ID-A, CHAMBER	304SS	1
LOG NO.	1001	SEQUENCE NUMBER	IDENTIFICATION OR DESCRIPTION	MATERIAL & SPEC	QTY

[illegible]